

Work Order ID 50739

July 21, 2009 12:43:33 PM

Page 1

Item ID: D3684-045
Revision ID: C
Item Name: LEG ASSEMBLY

Accept

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 4.00
Required Date: 7/15/09 Req'd Qty: 4.00

Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 1 2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684 1 ***Ensure holes for AN3C Bolts are free of

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

PL09-08-05

PL09-08-05 (4)

(P70)

=> 8 09/08/05

(24) 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-08-05	110	1 x NAS509-12C NUT batch: <u>M106993</u> Permanent chg	RE	09.08.05	4	RE	09.08.05	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50739

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Page 2

Item ID: D3684-045
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Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 4.00
Required Date: 7/15/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Memo

0.00

0.00

Q/8/5

ⓧ 42 SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

1090810
MF 09-08-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50739

Parent Item: D3684-045RevC

Parent Item Name: LEG ASSEMBLY

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	135.0000	8.0000			



Bolts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	135	
106993	7	
110155	2	
110552	4	
110584	72	
111916	50	

D3688-5RevB

Manufactured No

110 Each

11.0000 4.0000



STUD

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
46054	11	

D3689-1RevB

Manufactured No

110 Each

19.0000 4.0000



SLEEVE

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	19	
46051	19	

8 6/10/09-08-05

4 6/10/09-08-05

4 6/10/09-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 21, 2009 12:43:32 PM

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Work Order ID: 50739

Parent Item: D3684-045RevC

Parent Item Name: LEG ASSEMBLY

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3691-1RevB		Manufactured	No			110	Each	17.0000	4.0000			
STUD												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 17

46052 17

D3692-1RevB		Manufactured	No			110	Each	106.0000	16.0000			
SPACER												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 106

44827 68

45672 38

D3693-1RevB		Manufactured	No			110	Each	5.0000	4.0000			
Rod End Bearing												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

45723 5

350733 → ④ 09.08.05

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50739

Parent Item: D3684-045RevC

Parent Item Name: LEG ASSEMBLY


Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			110	Each	590.0000	8.0000			
												
Nut												

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

510

111819

210

112243

300

NAS509L12C

Purchased

No

110

Each

35.0000

4.0000



Nuts

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

106993

5

110844

30

8/10/09 08.05

3
1 8/10/09 08.05

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

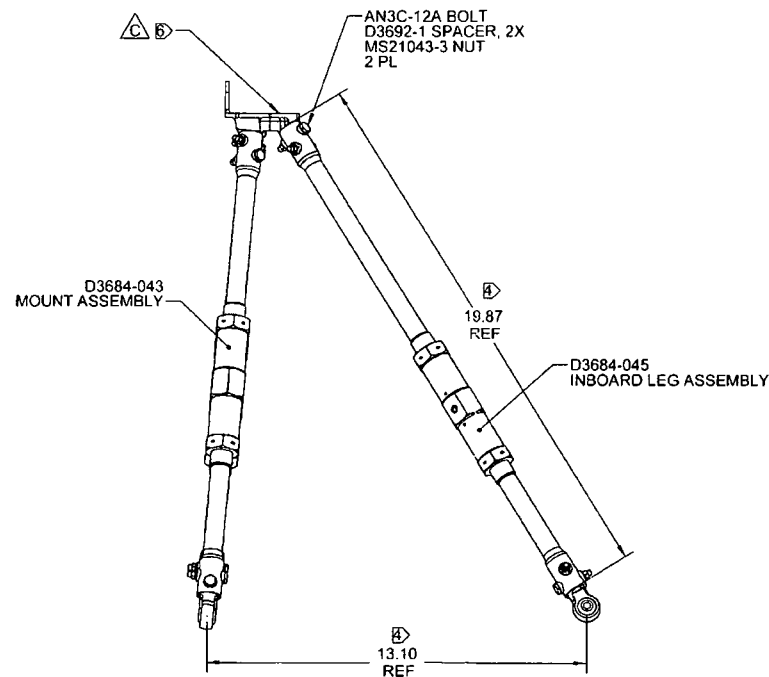
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

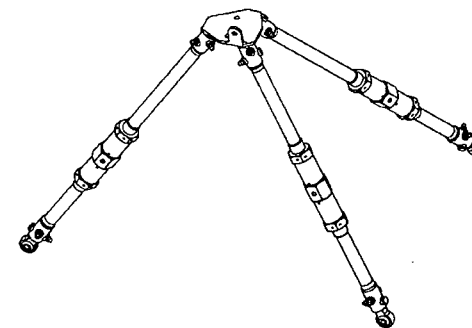
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT



D3684-041 TRIPOD MOUNT ASSY  

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs
- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

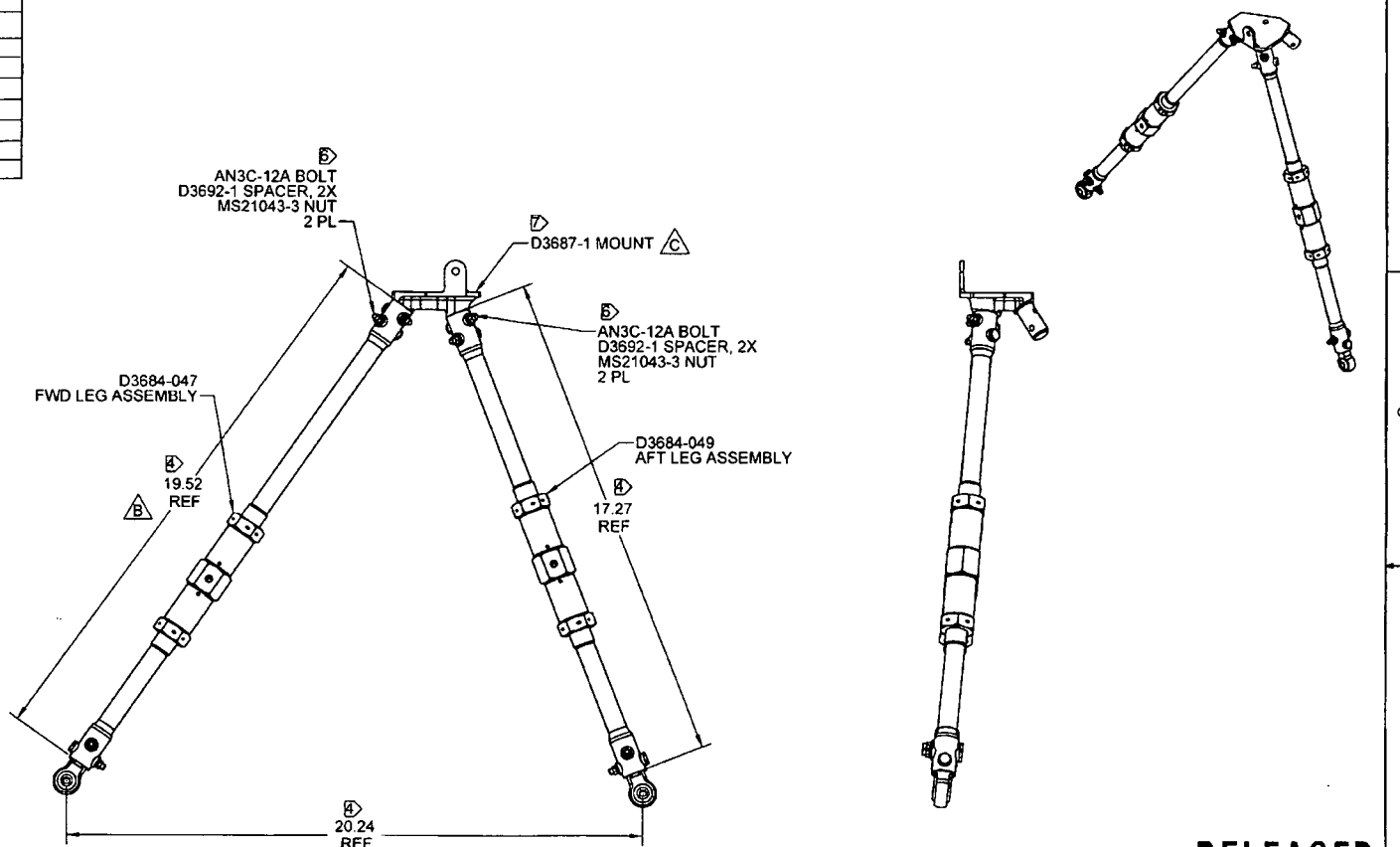


W/050739

RELEASED
08/12/15

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D8-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C6-4); 6.85 WAS 6.88 (ZND5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3684	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

NOTES:

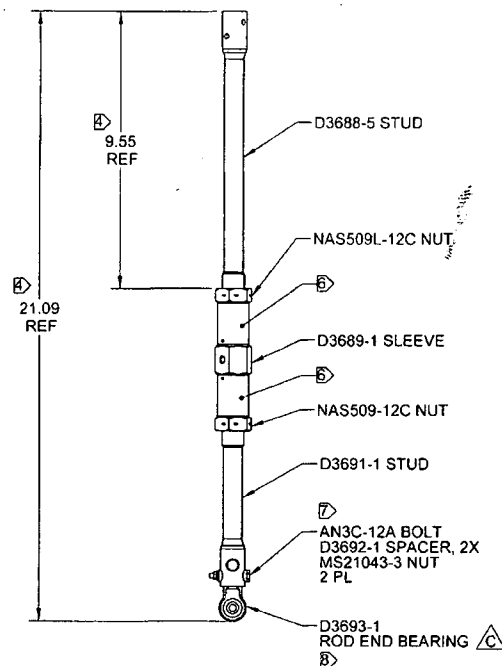
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
10/01/12

WU 50739

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	40	DRAWING NO.	REV. C
MFG. APPR.	40	D3684	SHEET 2 OF 5
APPROVED	40	TITLE	SCALE
DE APPR.	40	TRIPOD MOUNT ASSY	NTS
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ITEM	QTY .045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5 ✓	STUD
3	1	D3689-1 ✓	SLEEVE
4	1	D3691-1 ✓	STUD
5	4	D3692-1 ✓	SPACER
6	1	D3693-1 ✓	ROD END BEARING
7	2	AN3C-12A ✓	BOLT
8	2	MS21043-3 ✓	NUT
9	1	NAS509L-12C ✓	NUT
10	1	NAS509-12C	NUT



D3684-045 INBOARD LEG ASSEMBLY

NOTES:

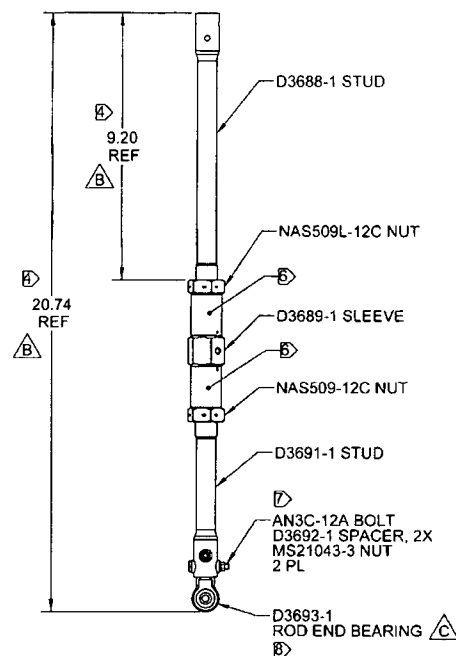
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

W10 50735

RELEASED
09/01/2010

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

UIC 50739

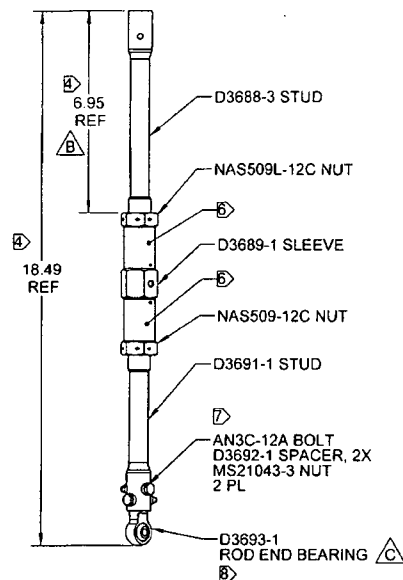
RELEASED
09/01/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

WRO 50739

RELEASED
09/01/14

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3684	REV. C
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE TRIPOD MOUNT ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND OWNED BY DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.12.15		